

Work Order ID 110133

December-17-13 9:15:50 AM

110133

Page 1

Item ID: D412-750-141

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Tail Light Fairing LH

Stop

NS2

Start Date: 12/17/13 Start Qty: 2.00

2

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLS Date: 12-12-13

Tooling:

Date:

Run Start

NR1

QC: Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
N/A	Rev A

100

0.00

100

DOCUMENT CONTROL

DC

Memo 11.10.

0.00

Document Control

Photocopy bluefile & type labels per PPP D412-750-141 CHG001

DAS
6
9-89

14/1/13

2x

MLA

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

2x

DAS
28
9-89

14-01-10

DAS
31
9-89

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

***** Ensure part is a L/H as per dwg *****

DAS
6
9-89

14/1/13

2x

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Page 2

Item ID: D412-750-141

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Start Date: 12/17/13

Start Qty: 2.00

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Cust Item ID:

Required Date: 12/17/13

Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Packaging

Packaging

Memo

FG

0.00

Identify and pack for shipping as per PPP D412-750-141 Location: 124

PPP Rev: _____

Identify on inside surface as indicated
TCCA-PDA,DART AEROSPACE LTD
P/N:D412-750-141 B/N:BXXXXX
FOR PRODUCT ELIGIBILITY SEE PDA06-13

14-1-14

DAS
6
8-88

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

14-01-14

① 14-DC-14

Picklist Print

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Page 1

Work Order ID: 110133

Parent Item: D412-750-141

Parent Item Name: Tail Light Fairing LH

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP revA 06.09.22 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-3A Bolt		Purchased	No			120	Each	311.0000	10	20			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				DAS 28 9-89	14-01-10
				ST350		311							
				123831		7							
				124552		1							
				m126192		1							
				m126249		102							
				m127044		200							
D3484-041 Tail Light Fairing Assembly, LH		Manufactured	No			120	Each	11.0000	1	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				DAS 28 9-89	
				ST198		11							
				106778		9							
				86880		1							
				94860		1							
NAS1149D03631 Washer		Purchased	No			120	Each	4,179.0000	10	20			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				DAS 28 9-89	
				GA		89							
				124392		89							
				ST294		11							
				113068		11							
				ST510a		4079							
				m126319		4079							

- 3.8 Fasten the D3484-041/-042 Tail Light Fairing complete with A2064-1683 Tail Light Assembly to the tailboom using the provided (10) AN3-3A bolts into the tailboom's existing holes. Torque bolts 15-25 lb-in (1.7-2.8 N-m). Refer to Figure 1, Detail A.

4.0 WEIGHT AND BALANCE

The following is the net weight increase associated with the installation of the D412-750-141/-142 Tail Light Fairing Kit.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-750-141 <i>Tail Light Fairing Kit, LH</i>	0.13 lb 0.06 kg	6.0 in 0.2 m	0.78 lb-in 0.01 kg-m	296.1 in 7.5 m	38.49 lb-in 0.45 kg-m
D412-750-142 <i>Tail Light Fairing Kit, RH</i>	0.13 lb 0.06 kg	6.0 in 0.2 m	0.78 lb-in 0.01 kg-m	296.1 in 7.5 m	38.49 lb-in 0.45 kg-m

5.0 PARTS LIST

Qty - 141	Qty - 142	Part Number	Description
X		D412-750-141	TAIL LIGHT FAIRING KIT, LH
	X	D412-750-142	TAIL LIGHT FAIRING KIT, RH
1		D3484-041	TAIL LIGHT FAIRING ASS'Y, LH
	1	D3484-042	TAIL LIGHT FAIRING ASS'Y, RH
10	10	AN3-3A	BOLT
10	10	AN960JD10	WASHER

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Page 1

Item ID: D412-750-141 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Tail Light Fairing LH
Start Date: 12/17/13 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 12/17/13 Req'd Qty: 2.00 ***2*** Customer:
Reference:
Approvals: Process Plan: MLS Date: 12-12-13 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
N/A	Rev A								
100	DOCUMENT CONTROL	0.00							
100									
DC	Memo <u>M.L.</u>	0.00							
Document Control	Photocopy bluefile & type labels per PPP D412-750-141 CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control	***** Ensure part is a L/H as per dwg *****								

MLS 14-01-10


2x DAS
28 14-01-10
989

